

Work Order ID 76984

\*76984\*

Page 1

November-24-11 2:42:07 PM

Item ID: D2741 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Blade, 350 Skidtube

Start Date: 24/11/2011 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 40.00 \*40\* Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/24 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2741	Rev C

100 BAND SAW 0.00  
 \*100\* Memo 0.00 F.K 11/12/06 41 0  
 Bandsaw Cut blanks 13.850" long +0.063" -0.000"  
 Jeaspa Bandsaw

110 HAAS CNC VERTICAL MACHINING #1 0.00  
 \*110\* Memo 0.00 11.12.8 41 0  
 HAAS 1 1-Machine per folio FA108  
 HAAS CNC vertical machine #1

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
 \*120\* Memo 0.00 11.12.8 41 0  
 QC Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76984

**\*76984\***

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November-24-11 2:42:07 PM

Item ID: D2741 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blade, 350 Skidtube  
 Start Date: 24/11/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 40.00 **\*40\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	JK	11-12-11		(41)			
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo 1-Deburr2-Bend per Dwg D2741	0.00 0.00	SB	11/12/13		(41)			
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		Switz/13		(41)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

November-24-11 2:42:07 PM

**Item ID:** D2741

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

**Item Name:** Blade, 350 Skidtube

Stop \*NS2\*

**Start Date:** 24/11/2011      **Start Qty:** 40.00

**\*40\***

**Cust Item ID:****Required Date:** 08/12/2011      **Req'd Qty:** 40.00

**\*40\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Outsource process - Heat Treat

0.00

**\*160\***

## Outsource1

## Memo

0.00

### Outsource process - Heat Treat

Issue P/O: 15671 Harden material as per Dwg D2741 Min. Ultimate  
Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141  
ksi Test report or Certification required  
Sand blast parts

CL 4/12/14 (41)

170 Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*170\***

## Packaging

## Memo

0.00

## Packaging

Ensure Test report or Certification attached

C12/2/3 (141)

180 QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

OC

## Memo

0.00

## Quality Control

Interlio

cents  
46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Work Order ID 76984

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 Start Date: 24/11/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Small Fab	0.00							
<b>*190*</b>									
Small Fab	Memo	0.00							
Small Fab	<u>1-Pass in deburring machine</u> 2-Grind off edges								
195		0.00							
<b>*195*</b>									
HandFinish	Memo	0.00							
Hand Finishing	clean with wash & wipe to remove oil								
200	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:20</u> FINISH TIME: <u>10:50</u> OVEN TEMPERATURE:								

41X ✓ M-L 12/02/13

41X ✓ M-L 12/02/13

M119480

4000F

10:50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Required Date: 08/12/2011 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
*210*									
QC	Memo	0.00							
Quality Control									
220	Identify as per dwg & Stock Location: <u>465</u>	0.00							
*220*									
Packaging	Memo	0.00							
Packaging									
230	QC21- Final Inspection - Work Order Release	0.00							
*230*									
QC	Memo	0.00							
Quality Control									

41 x 6 M 12/02/13  
 counted

12/21/14 41

M.C.J. 12/02/15

M.C.J. 12/02/15  
 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-24-11 2:42:11 PM

Work Order ID: 76984

**\*76984\***

Parent Item: D2741

**\*D2741\***

Parent Item Name: Blade, 350 Skidtube

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: D00.11.15Removed P/O turning - in house processEC  
 IPP Rev: E 06-03-20 As Per Rev C JLM  
 IPP Rev: F 06.04.20Added grinding after heat treating EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NB0.500X03.00 0		Purchased	No			100	f	161.0830	1.1541	48.59368			

**\*M4130NB0 500X03 000\***

**\*\***

4130 Bar 0.500 x 3.00

Location	Loc Qty	Loc Code
MAT030	48.583	
118616	48.583	
MAT034	112.5	
29 118585	48.56	
119269	63.94	

36.45 St. FK. 11/12/06  
 1331 St.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

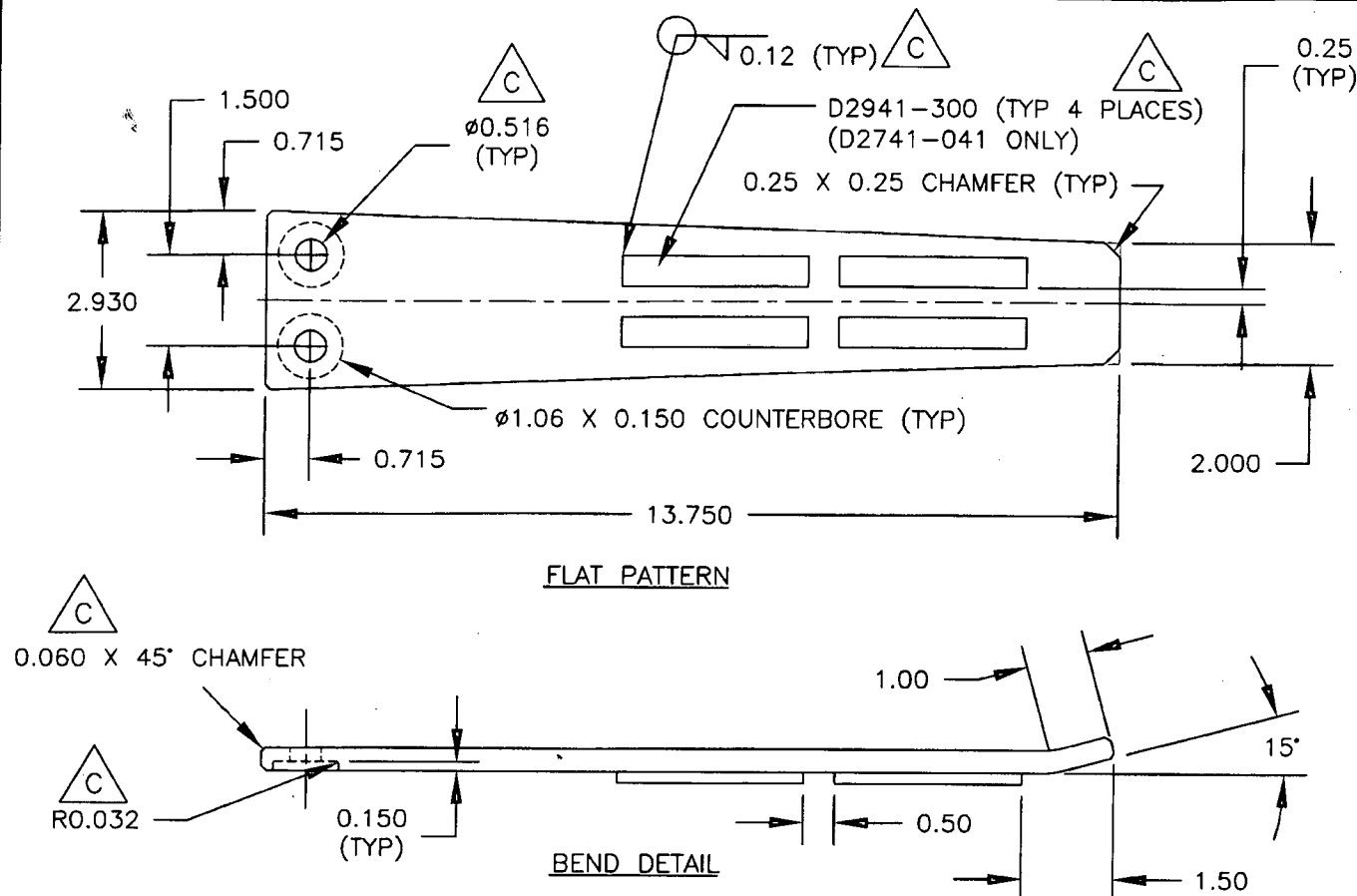
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

**RELEASED**  
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
04	04	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
06.01.12	06.01.12	D2741
DATE	TITLE	REV. C
06.01.12	BLADE	SHEET 1 OF 1
A	98.04.16	SCALE
B	98.09.01	1:3
C	06.01.12	
LARGER HOLE, ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS		
CHANGE C'SINK TO C'BORE		
NEW ISSUE		



#### D2741 BLADE

- 1) MATERIAL: AISI 4130 STEEL 0.375 THICK  
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)  
MIN. YIELD TENSILE STRENGTH = 141 ksi
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.030 TO 0.060
- 6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.  
REMOVE POWDER COAT FROM SURFACE OF D2941-300
- 7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

SHOP CO  
RETURN  
ENGINEER  
UNCONTROLLED  
SUBJECT TO AM  
WITHOUT NE  
WORK OR  
NO.

76984  
11/11/24

$\triangle C$

$\triangle C$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO15671

Purchase Order Date 12/14/11

PO Print Date 12/14/11

Page Number 1 of 1

Order From :

VC-MET004

METCOR INC.  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC J7R 5A8  
CA

Contact Name

Vendor Phone

450 473 1884

Vendor Fax

450 491 5498

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

*Call 12/14*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	76984	D2741 BLADES	12/29/11 Yes	41.00	FedEx PI ppd	\$10.3300	\$423.53

Special Inst: HARDEN MATERIAL AS PER DWG  
D2741  
MINIMUM ULTIMATE TENSILE  
STRENGTH= 152 KSI  
MINIMUM YIELD TENSILE STRENGTH  
= 141 KSI  
(34-40 HRC)  
NOTE: PLEASE SAND BLAST PART  
AFTER HEAT TREAT

PO Total:

\$423.53



*Call*

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 12/14/11

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Recu de Livraison

Order	Shipper	Shipping Seq.
172108	1	58004

Shipped Complete

**Customer** **215**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

**Shipped To:**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
15671		4130	2011/12/15	PUROLETTER

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

41 D2741 140,

BLADE

B76984

NOTE: PLEASE SAND BLAST AFTER HEAT TREAT

CONTENANT: 2 BC EPS

Container Type	# Of Containers	Container Comments
BC EPS	2	

<b>PACKING</b>	
----------------	--

Quantity Shipped: 41

Pounds Shipped: 140,00

Quantity Remaining: 0

Pounds Remaining: 0,00

Quantity Shipped: 41

Pounds Shipped: 140,00

Signature:

Date:

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client. / We certify that all the information on this report is exact and in accordance with the order requirements.

F-000-20 REV.B



Metcor Inc.  
Page 2 of 2  
St-Eustache (Québec) J7R 5A8  
Tél : 450 473-1884  
Télécopieur/Fax administration : 450 491-5498  
Télécopieur/Fax production : 450 491-6454

**Certificat de Conformité**  
**Certificate of Compliance**

BON DE TRAVAIL order	CHARGEMENT load
172108	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
15671		4130		

**SPÉCIFICATIONS DU PROCÉDÉ**

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	41	36 - 38 HRC
TENSILE (KSI)	152 - 182 KSI		161 - 171 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
41	140	D2741 BLADE B76984 NOTE: PLEASE SAND BLAST AFTER HEAT TREAT  CONTENANT: 2 BC EPS

**COMMENTAIRES / comments**

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPEMENT THAT MEETS THE REQUIREMENTS OF AMS 2759. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

INSPECTEUR / inspector:

DATE: 2012-02-01

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
172108	1

CLIENT / customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
15671		4130		

### SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN  
HARDEN AND TEMPER  
SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	41	36 - 38 HRC
TENSILE (KSI)	152 - 182 KSI	826/10	161 - 171 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
41	140	D2741 BLADE B76984 NOTE: PLEASE SAND BLAST AFTER HEAT TREAT  CONTENANT: 2 BC EPS

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1,00 CONT. INIT.	LAVAGE		si nécessaire							
2,00 PREPARING	COMPTAGE									
3,00 PREHEAT 1	1000	1:00 1:30	air			133				
4,00 SEL HARDE	1575	0:40	SEL		BRINE	106				
5,00 WASH	150	0:30	soap							
6,00 SNAP TEMP	400	2:00	air			609				

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
172108	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

Operation	Temp. spécifiée Specified Temp	Temps de trempe Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
7,00 SANDBLAS			Sablage							
8,00 DIST INSP										
9,00 TEMPER	875 +/-10°F	4 hrs	air			612				
10,00 HARDN INS										
11,00 SANDBLAS			Sablage							
12,00 HUILAGE			huile							
13,00 FINAL INSP							01-30-2012			01-30-2012

### COMMENTAIRES / comments

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPEMENT THAT MEETS THE REQUIREMENTS OF AMS 2759. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

APPROUVÉ par / Approved by:

*Vincent Carstensen*

DATE: 2012-01-31

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client./We certify that all the information on this report is exact and in accordance with the order requirements.